

Work Order ID 107022

September-16-13 11:28:28 AM

107022

Page 1

Item ID: D4018-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib

Start Date: 9/16/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/30/13

Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: MCS

Date: 13-09-16

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4018

D

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4018

2- debur and remove identification markings

8x

CC 13-9-16

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

8x

SH 13-09-17

120

Identify as per dwg & Stock Location: W1005

0.00

120

Packaging

Memo

0.00

Packaging

8x

SH 13-09-17

Work Order ID 107022***107022***

Page 2

September-16-13 11:28:28 AM

Item ID: D4018-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 9/16/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 9/30/13

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 13-09-20
MLJ 13-09-20

Picklist Print

September-16-13 11:28:28 AM

Page 1

Work Order ID: 107022

Parent Item: D4018-1

Parent Item Name: Rib

Start Date: 9/16/13

Required Date: 9/30/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: new issue DD 09.11.26 verified by:EC
10.03.15 verified by:EC IPP Rev:B as per dwg revA
IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC
IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC
6 DD verified by:ec IPP Rev:E 11.01.31 chg qc5 to

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	1,073.8606	4.73	39.831579		CC 13-9-16	

Location

Loc Qty

Loc Code

WA006

1073.860633

123484

2.22918950

125124

205.405667

125575

122.882777

M126039

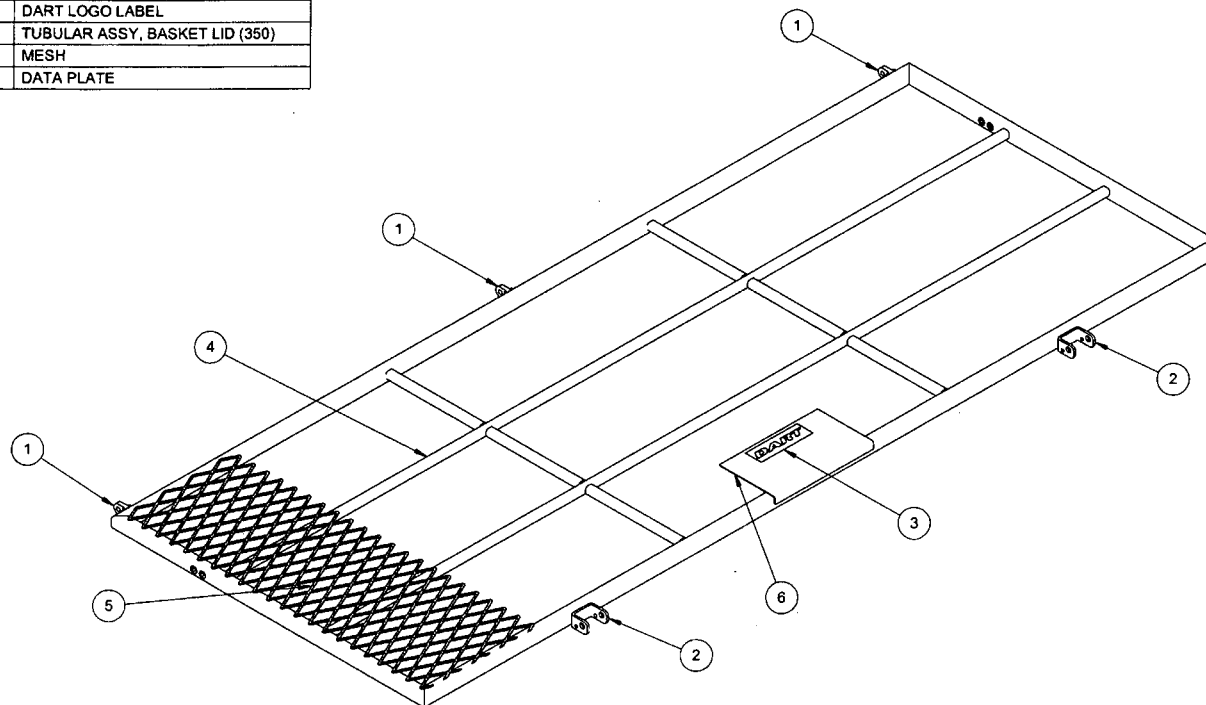
143.343

M126364

600

40.

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



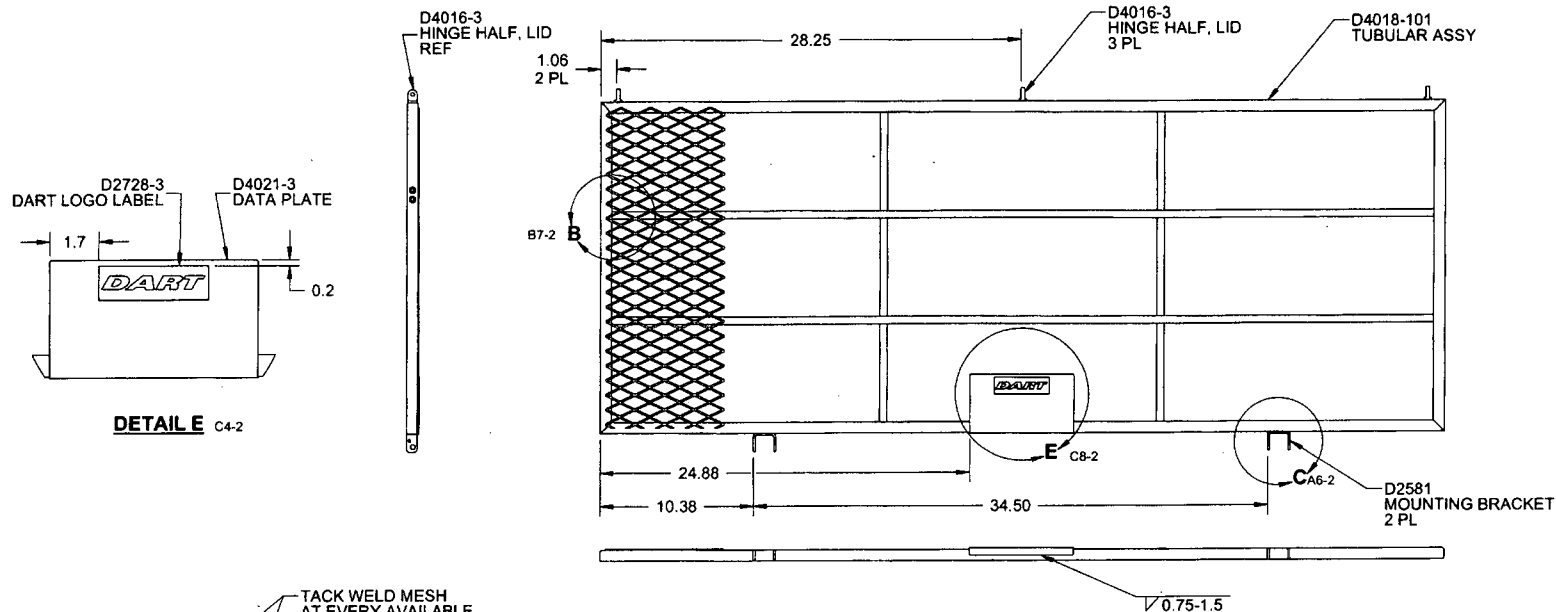
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

107022 MJS
13-09-16

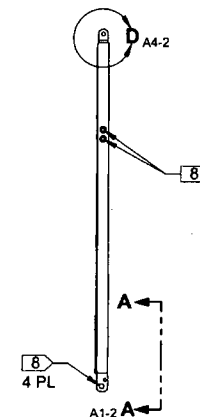
RELEASED
2013-08-16

D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED).	AJS	13.07.18
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES, PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO.	REV. D
MFG. APPR.	[Signature]	D4018	SHEET 1 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	SHORT BASKET LID ASSY (350)	NTS
DATE	13.07.18	<small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

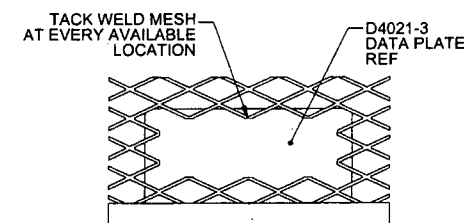
107022



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



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2013-08-16



VIEW A-A C1-2

DETAIL E C4-2

DETAIL B C6-2

DETAIL C C3-2

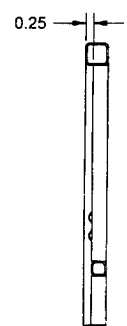
DETAIL D D1-2

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

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MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHORT BASKET LID ASSY (350)	NTS
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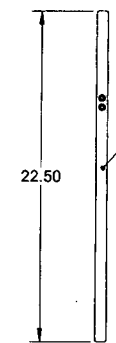
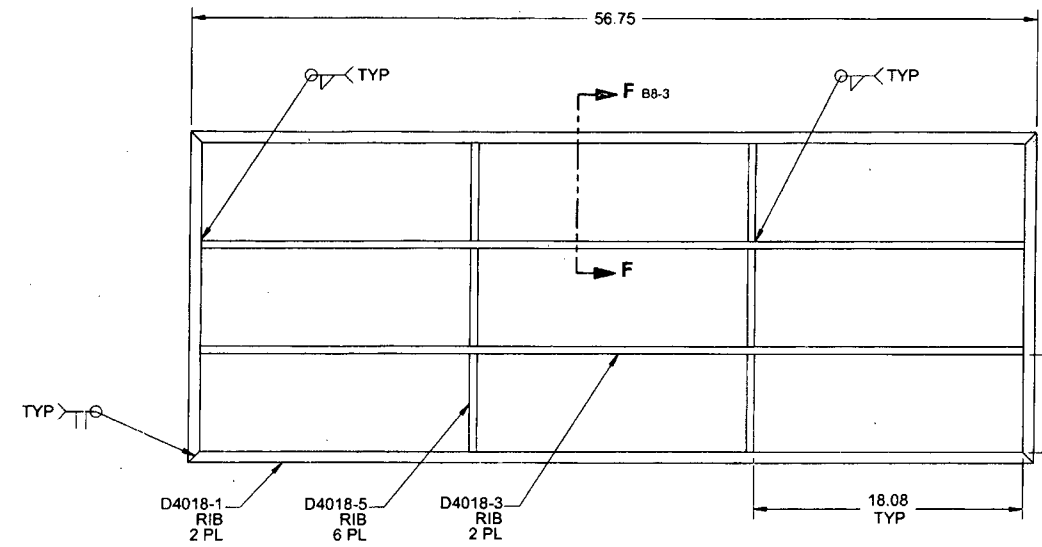
107027

ITEM	QTY	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



D4035-043
RIB ASSY, AFT

SECTION F-F C3-3



D4035-043
RIB ASSY, AFT

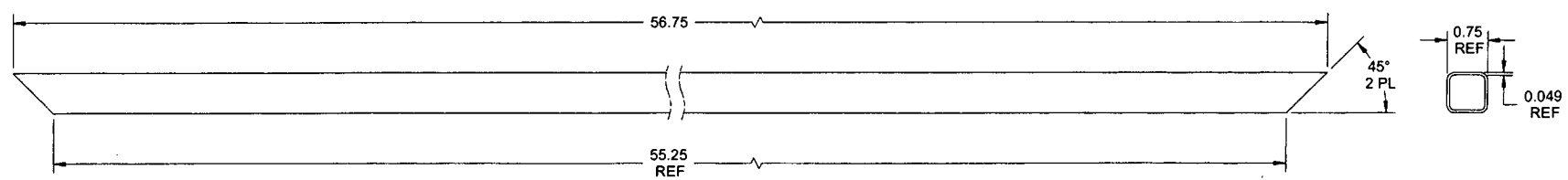
B D4018-101 TUBULAR ASSY, BASKET LID (350)

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2013-08-16

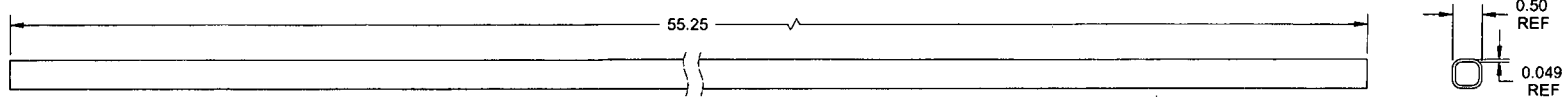
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.06 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

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DRAWN	AJS		
CHECKED		DRAWING NO. D4018	REV. D
MFG. APPR.		SHEET 3 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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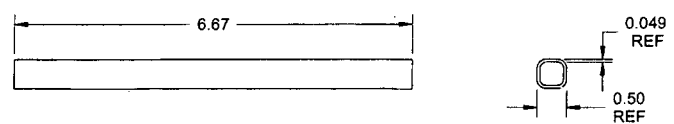
107022



D4018-1 RIB



D4018-3 RIB



D4018-5 RIB

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2013-08-16

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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MFG. APPR.	<i>[Signature]</i>	D4018	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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